

Date: Friday, 9/1/2006 12:17:06 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, INBOARD, LS, 206  
 Job Number : 28405  
 Estimate Number : 10820  
 P.O. Number : N/A Part Number : D26661  
 This Issue : 9/1/2006 S.O. No. : N/A Drawing Number : D2666 REV. C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C  
 Previous Run : 27966 Material : N/A  
 Written By : Due Date : 9/30/2006 Qty: 12 Um: Each  
 Checked & Approved By : *[Signature]*  
 Comment : Est: C 00/11.01 Removed P/O for Powder Coat - in house processEC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock:

Cut Size 2.0 x 6.25 X 6.0

Grain Along Long 6.0 Length

Batch No: *B25344*

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

2-Fixturing Inspection last completed on *06/11/12* by *J.L.*

3-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

8-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

9- Deburr

*J.L. 06/09/13*

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

*J.L. 06/09/13*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.L. 06/08/13*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

Date: Friday, 9/1/2006 12:17:06 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 28405

Part Number: D26661

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*9ml 06/09/13*

*12*

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*SAD 06:09:14*

*(12)*

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*FC 06 09 15 (12)*

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

*PC 4/9/18 (12)*

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5771*

*PC 4/9/18*

*12*

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



*U 06-09-18*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28405
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2666-1
<b>Inspection Dwg:</b> D2666 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.122	.121	.121		
B	0.100	0.140		.120	.121	.121	.122		
C	2.470	2.510		2.490	2.490	2.490	2.490		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.220	.220	.220	.219		
F	1.313	1.343		1.327	1.326	1.326	1.328		
G	0.240	0.260		.250	.248	.250	.250		
H	0.615	0.685		.655	.655	.655	.655		
I	1.125	1.145		1.134	1.134	1.134	1.135		
J	0.990	1.010		1.001	1.000	1.000	1.000		
K	0.235	0.240		.238	.238	.238	.238		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.120	.120	.112	.112		
N	1.565	1.585	DT8888						
O	5.990	6.010		6.000	5.999	5.999	6.000		
P	1.245	1.255		1.249	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.500	.499	.500	.500		
S	0.313	0.318	DT8686						
T	2.495	2.505		2.500	2.500	2.560	2.500		
U	1.357	1.367		1.362	1.361	1.361	1.362		
V	0.313	0.318	DT8686						
W	0.540	0.560		.550	.550	.549	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262	DT8683						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JL
Date: 06/09/12

Audited by: CML
Date: 06/09/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	28405
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	D2666-1
<b>Inspection Dwg:</b> D2666 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.122	.122	.122	.121		
B	0.100	0.140		.122	.122	.122	.121		
C	2.470	2.510		2.490	2.490	2.490	2.490		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.221	.220	.221	.219		
F	1.313	1.343		1.329	1.328	1.329	1.327		
G	0.240	0.260		.250	.249	.250	.250		
H	0.615	0.685		.655	.655	.655	.655		
I	1.125	1.145		1.133	1.135	1.134	1.135		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.239	.239	.239	.239		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.114	.112	.112	.113		
N	1.565	1.585	DT8888	/	/	/	/		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.500	.500	.500	.501		
S	0.313	0.318	DT8686	/	/	/	/		
T	2.495	2.505		2.500	2.499	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.313	0.318	DT8686	/	/	/	/		
W	0.540	0.560		.550	.550	.550	.551		
X	1.674	1.684		1.679	1.678	1.679	1.679		
Y	0.257	0.262	DT8683	/	/	/	/		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	06/09/13

Audited by:	gml
Date:	06/09/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28405
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2666-1
<b>Inspection Dwg:</b> D2666 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

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				1	2	3	4		
A	0.100	0.140		.121	.121	.121	.121		
B	0.100	0.140		.122	.122	.121	.123		
C	2.470	2.510		2.490	2.490	2.490	2.490		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.221	.222	.221	.222		
F	1.313	1.343		1.327	1.328	1.327	1.328		
G	0.240	0.260		.250	.250	.248	.249		
H	0.615	0.685		.655	.655	.655	.655		
I	1.125	1.145		1.135	1.135	1.135	1.136		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.239	.238	.238	.238		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.113	.112	.112	.113		
N	1.565	1.585	DT8888						
O	5.990	6.010		6.001	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.498	.501	.500	.498		
S	0.313	0.318	DT8686						
T	2.495	2.505		2.500	2.500	2.499	2.500		
U	1.357	1.367		1.362	1.362	1.361	1.362		
V	0.313	0.318	DT8686						
W	0.540	0.560		.550	.550	.551	.550		
X	1.674	1.684		1.678	1.679	1.679	1.679		
Y	0.257	0.262	DT8683						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

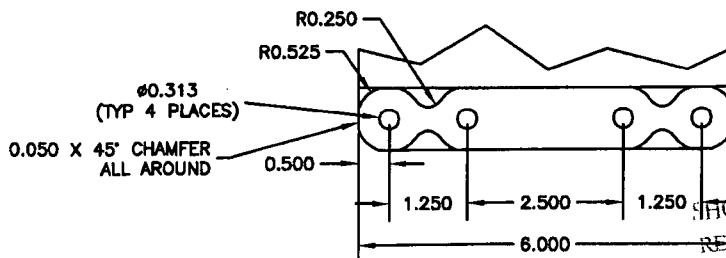
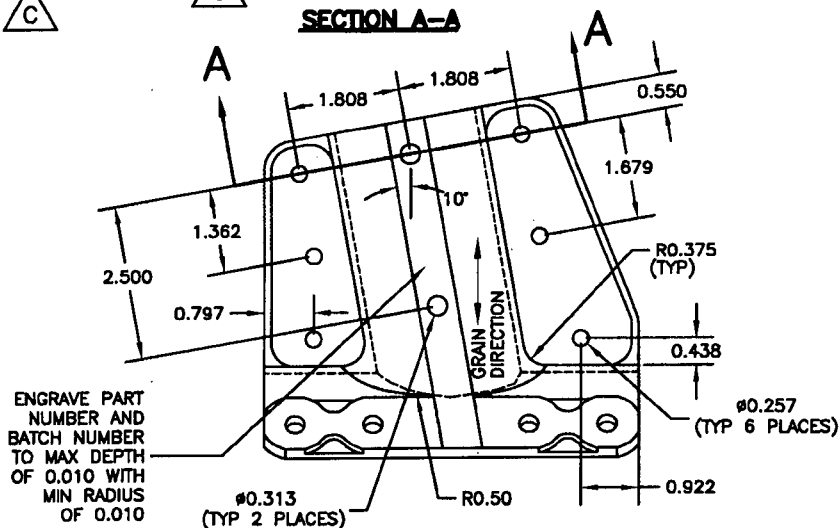
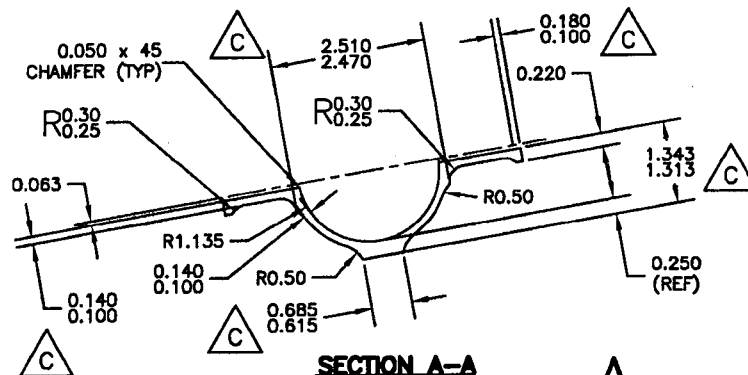
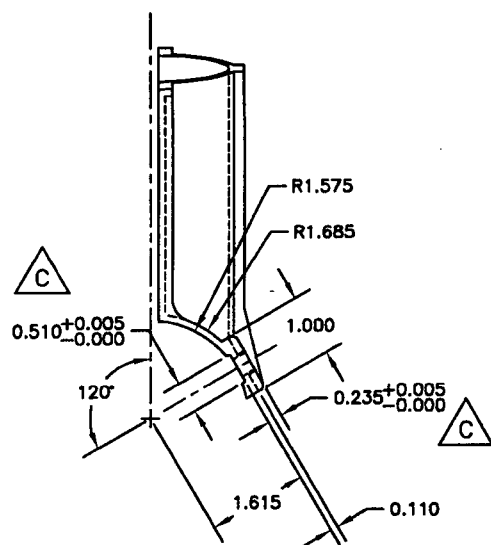
Measured by:	J.L
Date:	06/09/13

Audited by:	me
Date:	06/09/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

**DART****RELEASED**  
de de 24 H

DESIGN #	DRAWN BY C.B.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED B	APPROVED H	DRAWING NO. D2666	REV. C SHEET 1 OF 1
DATE 06.05.26		TITLE SADDLE FWD INSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	

**D2666-1 SADDLE FWD INSIDE HIGH****NOTES:**

- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

STOP COPY  
RETURN TO  
ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28405

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